

Work Order ID 72083

Tuesday, July 19, 2011 9:53:31 AM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

SAD 11-07-21

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: M115778

7- grind weld flush

8- deburr if necessary

[Signature] 11.07.21 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

✓ 6 0 361/07/21

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

✓ 11 57 22 (6)

150

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

SAD 11-07-22 (6)

W/O:		WORK ORDER CHANGES					
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Page 3

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Stop



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Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/22

11-07-22
(4)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, July 19, 2011 9:53:36 AM

Page 1

Work Order ID: 72083

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)

Start Date: 7/19/2011


Required Date: 7/26/2011

Start Qty: 6.00

Required Qty: 6.00


Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1  Bushing		Manufactured	No			100	Each	173.0000	3	18			
---	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	171	
69202	171	
WA005	2	
66489	2	

M304TS0.750W.065  304 SQ Tube .75x.75x.065W		Purchased	No			100	f	634.8213	8	50.52632			
--	--	-----------	----	--	--	-----	---	----------	---	----------	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

MAT018	91.83716	
117598	14.13846	
117636	77.6987	
WA	500	
118181	500	
WA007	42.9840906	
116267	36.391372	
116763	6.5927186	

11-07-21

18

50.5264

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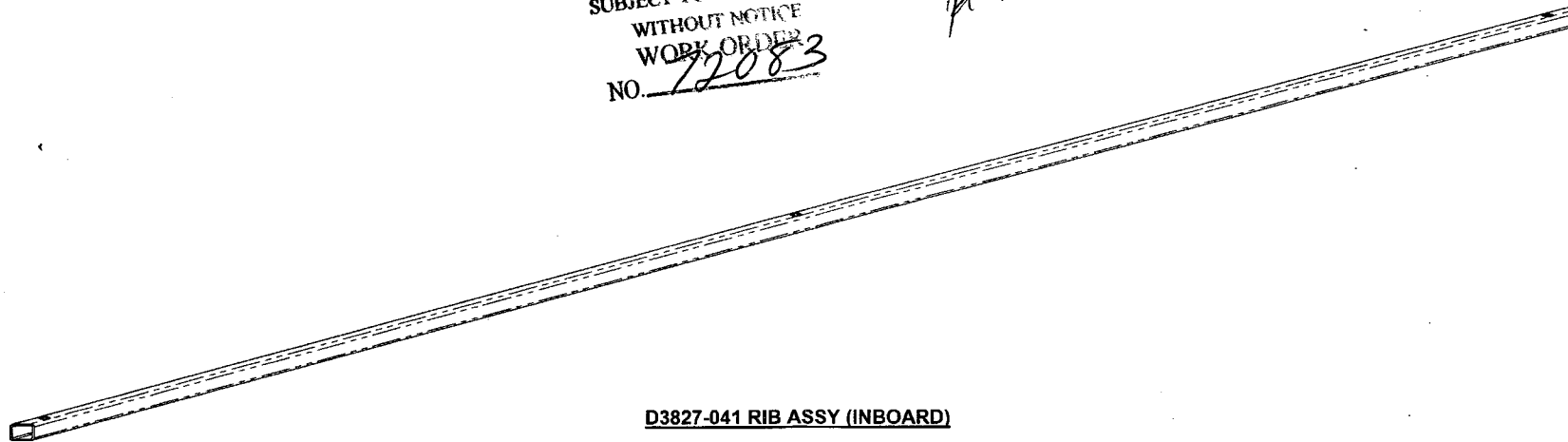
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72083

1107-19



D3827-041 RIB ASSY (INBOARD)

RELEASED
08/11/13

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3827** REV. A
SHEET 1 OF 3

TITLE **RIB ASSY (INBOARD)** SCALE
NTS

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8 7 6 5 4 3 2 1

D

D

C

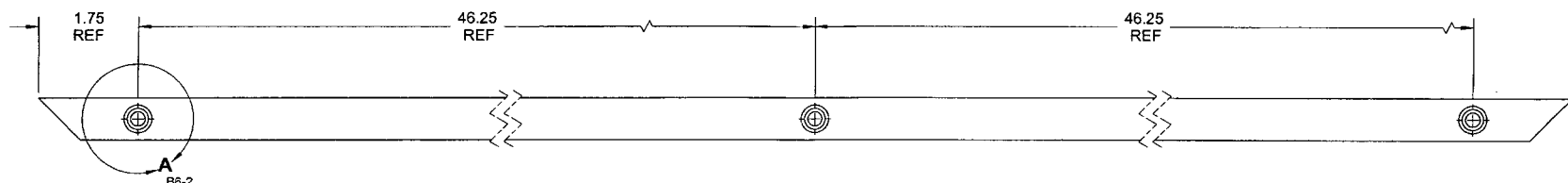
C

B

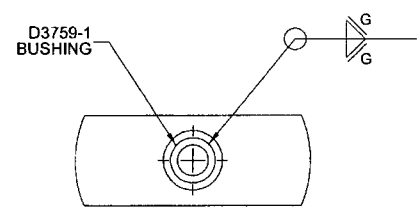
B

A

A



D3827-041 RIB ASSY (INBOARD)



DETAIL A
SCALE 2X C7-2
3 PL

72083

RELEASED
08/11/18 NY

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MS	DRAWING NO.	REV. A
MFG. APPR.	MS	D3827	SHEET 2 OF 3
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DE APPR.	MS	RIB ASSY (INBOARD)	NTS
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8 7 6 5 4 3 2 1

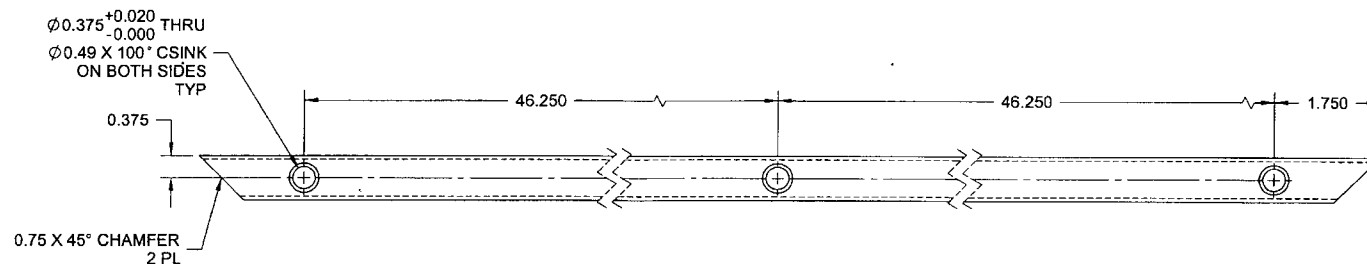
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D3827-1 RIB

72083

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.55 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
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